

Work Order ID 148098***148098***

Page 1

Friday, June 24, 2016 10:38:15 AM

Item ID: D2574

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, In

Start Date: 6/15/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2574

F

100

0.02

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.74

HAAS CNC vertical machine #1

Program Batch No. **B148098**

DAS

Double check by: **20**

9-89

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

B. 16/07/07 12
P 16/07/10

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.06

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

B. 16/07/07
P 16-07-09

12

1 48098

Friday, June 24, 2016 10:38:15 AM

N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

120

OC

Memo

0.02

Quality Control

D. = 16/07/07
16-07-10

0.00

130

QC

Memo

0.04

Quality Control

12 07 _____

DAS
49
9-89

16/07/11

0.00

140

HandFinish

Memo

0.06

Hand Finishing

12 _____ 2016/07/01
BEB.

Work Order ID 148098

Friday, June 24, 2016 10:38:15 AM

148098

Page 3

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, In
Start Date: 6/15/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 6/27/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.2 Alum <i>M 134631 13478</i>	0.00							
	Memo START TIME: <u>7:55</u> OVEN TEMPERATURE: <u>300°</u> FINISH TIME: <u>8:25</u>	0.04							
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02							DAS 38 9-89 JUL 13 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>51398</u> Memo	0.00 0.02							DAS 6 9-89 JUL 13 2016

Picklist Print

Page 1

Friday, June 24, 2016 10:38:14 AM

Work Order ID: 148098

148098

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft, In

Start Date: 6/15/2016

Required Date: 6/27/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	20.0000	1	12			
D6101-005									**				
Saddle Billet													

DAS
44
9-89

16-07-05

Location

Loc Qty

Loc Code

MAT040

20

146278

20

147082

12

DART AEROSPACE LTD		Work Order: 148098
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.497	0.500	0.500	0.499		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.567	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.251	0.252	0.252	0.252		
S	0.115	0.135		0.127	0.127	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.240	0.240	0.240		
W	0.115	0.135		0.132	0.131	0.132	0.132		
X	0.307	0.312		0.312	0.312	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.365	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.246	0.247	0.246	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: B. S.	DAS
Date: 16/03/07	08
	9:00

Audited by: [Signature]
Date: 16/07/11

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 148098
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8		
A	0.438	0.443		0.438	438	.438	438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8000	8000	8000		
F	0.490	0.510	0.50	0.497	0.50	499	.500		
G	0.257	0.262		0.258	258	.258	.258		
H	0.375	0.380		0.376	376	.376	.376		
I	0.490	0.510	0.50	0.500	.5005	.503	501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578	0.56	0.567	.566	0.566	566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129	4.124 →	4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	135	0.135	.135		
Q	0.115	0.135		.129	126	126	125		
R	0.240	0.260		.253	253	253	.253		
S	0.115	0.135		.126	.126	126	.127		
T	0.178	0.198		0.188	.188	188	188		
U	3.210	3.250		3.230	3.230	3.230	3.250		
V	0.230	0.250	245 →	242	242	242	.242		
W	0.115	0.135		.126	.126	121	121		
X	0.307	0.312		.311	311	310	308		
Y	0.760	0.765		0.760	.760	760	.760		
Z	0.352	0.372		.368	.365	365	.360		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635	0.62	0.625	.627	.625	625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		.254	.251	251	252		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.265	.270	.270	.270		
AH	0.240	0.260		.251	.251	249	250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	.033	.033	.033		

Accept/Reject

49

Measured by:	AP-07-10
Date:	

Audited by:	0-89
Date:	16/07/11

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 118098
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.438	0.443		0.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510	OK	.501	.500	.500			
G	0.257	0.262		0.258	.258	.258	.258		
H	0.375	0.380		0.376	.376	.376	.376		
I	0.490	0.510	OK	.504	.502	.502	.502		
J	1.174	1.184		1.179	1.177	1.179	1.179		
K	0.558	0.578	OK	.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	.135	.135	.125		
Q	0.115	0.135		.124	.124	.124	.124		
R	0.240	0.260		.253	.252	.250	.250		
S	0.115	0.135		.127	.128	.128	.128		
T	0.178	0.198		0.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.243	.242	.245	.244		
W	0.115	0.135		.120	.125	.123	.125		
X	0.307	0.312		.311	.308	.301	.308		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		.358	.363	.363	.363		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.625	.625	.625	.625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		.253	.253	.254	.253		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.265	.265	.265	.265		
AH	0.240	0.260		.251	.250	.255	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	.033	.033	.033		

Accept/Reject

49

Measured by:	P16-07-10
Date:	

Audited by:	9-89
Date:	16/07/11

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

